

Day, 05/05/2008 11:11:50 AM
a Lacelle

Process Sheet

: CU-DAR001 Dart Helicopters Services Drawing Name : TUBE
 Number : 39032
 Estimate Number : 13296
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : R & D SM/MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Part Number : D37851
 Drawing Number : D3785 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM 08.05.21
 Material :
 Due Date : 08/05/2008 Qty: 2 Um: Each

POSITIVE
RECALL

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

M304TG1250W120

304 SQ Tube 1.250x1.250x120w

Comment: Qty.: 1.0542 f(s)/Unit Total: 2.1084 f(s) Batch: m108090
 304 SQ Tube 1.250x1.250x120w 6061-T6 SQ Tube 1.250x1.250x120w
 batch: M107983 FF 08-05-22 (2)
 FF 08-05-14 (2)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut to length as per dwg D3785

FF 08-05-22 (2)

2-drill hole one side of tube as per dwg D3785

FF 08-05-14 (2)

3.0

QC5

INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL

Comment: INSPECT WORK TO CURRENT STEP

08.05.14 (2)
 08.05.14 (2)

4.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and stock

Location: _____

Quarantine

08/05/26 (2)

5.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

08/05/27 (2)
 080604 Prototype
 MF 08-05-27

Job Completion

POSITIVE RECALL

EFFECTIVE 08.05.05 AUTHN


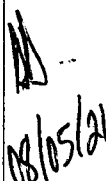



RELEASED

DATE 08.05.22

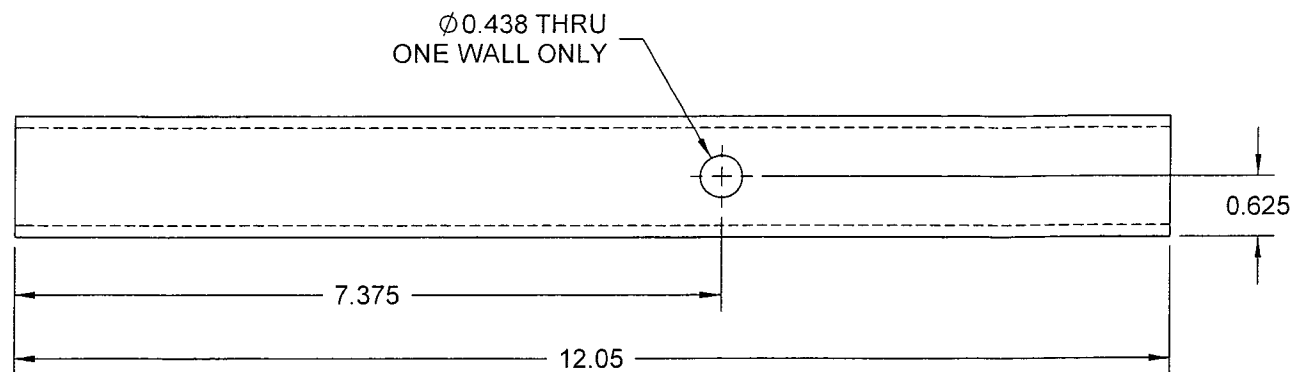
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3785-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

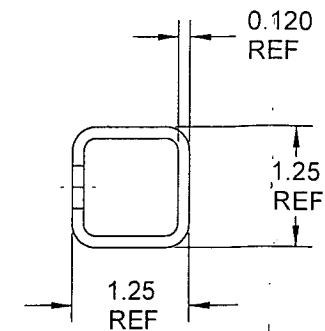
QA: N/C Closed: _____ Date: _____

NCR: <u>39032</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/05/21</u>		Scrap due to material chg. S.S. to Alum 6061 T6		Scrap and destroy all parts Reduce with new material chg	 <u>08/05/21</u>	 <u>08-05-22</u>	 <u>08-05-22</u>	 <u>08-05-22</u>
				- Replace on this w/o Qty 1 <u>M 108090</u>	FF <u>08/05/22</u>			

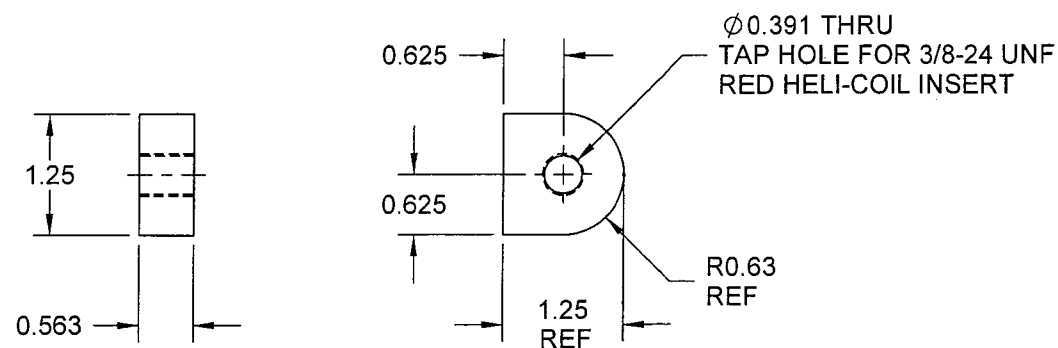
NOTE: Date & initial all entries



D3785-1 TUBE



00224A



D3785-5 FIXTURE

D3785-1/-5 NOTES:

- 1) MATERIAL:
 - D3785-1: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING, 1.25 X 1.25 X 0.120 WALL, PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6TS1.250W.120)
 - D3785-5: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: - D3785-1 = 0.59 lbs
- D3785-5 = 0.25 lbs

PROTOTYPE
PRELIMINARY ISSUE
08.05.21

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3785	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ARMREST WELDMENT	NTS
DATE	08.04.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

VR0004

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By:

Design Manager Approval:

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F ✓	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1 ✓	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F ✓	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F ✓	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5 ✓	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041 ✓	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1 ✓	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3 ✓	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5 ✓	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3781-041	CUSHION ASSEMBLY _{OK}	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3781-1	SUPPORTING PLATE _J	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
1	D3781-3	CUSHION _{OK}	08.04.29	N	END OF MAY	GET QUOTE FROM CHESTNUT RIDGE DAN STOW WILL MAKE ONE FOR TESTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:11:50 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : TUBE
 Job Number : 39032
 Estimate Number : 13296
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : R & D SM/MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Part Number : D37851
 Drawing Number : D3785 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM
 Material :
 Due Date : 08/05/2008 Qty: 2 Um: Each

POSITIVE RECALL

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TQ4250W429 304-SQ Tube 1.250x1.250x.120w



M6061 T6 TS 1250W120



Comment: Qty: 1.0542 f(s)/Unit Total: 2.1084 f(s) Batch: m108090 comes P10.6375. → FF 08-05-22 (2)

304-SQ Tube 1.250x1.250x.120w

batch: M70790833016271 (m108090)

FF 08-05-14 (2)

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut to length as per dwg D3785

FF 08-05-22 (2)

2-drill hole one side of tube as per dwg D3785

FF 08-05-14 (2)

3.0 QC5 INSPECT WORK TO CURRENT STEP



ENGINEERING APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

S. Odell 14 (2)

08-05-14 (2)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Quarantine

08/05/26 (2)

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27 (2)

Job Completion



POSITIVE RECALL

EFFECTIVE 08-05 AUTHN

RELEASED

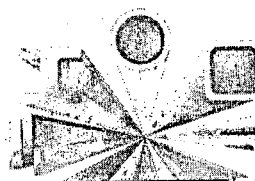
DATE 08-05-27

MF 08-05-27



935, boul. du Havre
Valleyfield (Québec)
J6S 5L1

TÉLÉPHONE : 450 37
FAX : 450 37



VENDU À / SOLD TO:

EXPÉDIEZ À /

613-632-5200

613-632-1053

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

DART AEROSP
1270 ABERDE
HAWKESBURY,
ONTARIO
K6A 1K7

VOTRE N° DE COMMANDE / YOUR P.O. N°: 6375
VEND. / SALESM. D
CODE CLIENT / CUST. CODE DAER
EXPÉDIE PAR / SHIP VIA

✓ NOMBRE QUANTITY	CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DI
34212	40	2 x 20	H.P. FLAT 3/4 x 2	
			2 x 20	
			118/12/13	
			ALUM. 2024	
			21 SHEET	
			ALUM. 2024	
			21 SHEET	
PSS48166	3	2 x 1	ALUM. 2024	
			21 SHEET	
ITAL114114125R	20	1 x 20	ALUM. 2024	
			21 SHEET	

Unités de mesure: CLB Cent livres • CPI Cent pieds • UN Unité • PI Pied • PC Pied carré
Units of measure: Hundred pounds • Hundred feet • Unit • Foot • Square foot

CONDITIONS:

LES MATERIAUX LIVRES ET FACTURES TELS QUE DÉCRITS DÉMEURENT LA PROPRIÉTÉ DE "ACIER CAMP I INC." JUSQU'À PARFAIT PAIEMENT COMPLET. LES RISQUES DE PERTES OU BIEN SONT À LA CHARGE DE L'ACHETEUR. LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES: NET 30 JOURS DE LA DATE DE FACTURATION; ET TOUT COMPTÉ IMPAYÉ DANS LES 30 JOURS ENTRAÎNE DES PRAIS DE 2% PAR MOIS (24% PAR ANNÉE) QU'IL ACCEPTE DE PAYER. TOUT DÉFAUT D'EXÉCUTER L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU REPRISE LE BIEN VENDU. TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUR PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTOMATISATION. TOUTE MARCHANDISE RETOURNÉE EST SOUJETTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS:

GOOD AND DELIVERED MATERIALS ARE AT THE RISK OF THE BUYER. THE QUALITY WARRANTY OF THE MATERIAL IS THE SAME AS THAT OF THE MANUFACTURER. THE BUYER AGREES TO THE FOLLOWING CONDITIONS: NET 30 DAYS FROM THE DATE OF INVOICING; AND ANY UNPAID INVOICE WITHIN 30 DAYS WILL INCURE CHARGES OF 2% PER MONTH (24% PER YEAR) WHICH HE ACCEPTS TO PAY. ANY DEFAULT IN FULFILLING ONE OR MORE OF THE OBLIGATIONS UNDER THE PRESENT CONTRACT WILL LEAD TO THE TERMINATION OF THE TERM AND WILL PERMIT THE SELLER, AT HIS OPTION, TO CLAIM THE BALANCE OF THE SELLING PRICE OR TO TAKE BACK THE GOODS. ALL CLAIMS MUST BE MADE WITHIN FIVE DAYS OF PRESENTATION OF THIS DOCUMENT. DAMAGED, ALTERED OR CUT MATERIAL CANNOT BE TAKEN BACK. NO RETURN OF MATERIALS WILL BE ACCEPTED WITHOUT OUR AUTOMATICATION. ALL RETURNED MATERIALS ARE SUBJECT TO A 25% RESTOCKING FEE.

PRÉPARÉ / PREPARED	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR BY	PAR BY	PAR BY	11/10/03

N° ENR. TPB / GST REG. N° R 135 634717 • N° ENR. TVQ / GST REG. N° 1 015 668 543

SIGNATURE DU

H:\FORMS\Purchasing\approved purch\RECREPORT Rev)

Production/Admin: 08/05/13
Date: 08/05/13
Received/Costing: RCP 7449
Initial: CR

Location

Initial of receiver (if shipment OK) Level 12

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M 200473500		46	0	0	46	
M 200473500		46	0	0	46	
M 200473500		46	0	0	46	

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Date: 08/05/13
Supplier: CAMP I

Batch No: M108090
Dart P/O: 6375
F Release Note Attached: Yes ☐ No ☒
V aybill Attached: Yes ☐ No ☒
S Shipment Complete: Yes ☐ No ☒
C C6 Inspection: Yes ☐ No ☒
V ork Order: Yes ☐ No ☒

Receiving Report

PTD-7

11113
18 OCT. 2007



LONGKOU NANSHAN ALUMINIUM GENERAL FACTORY

NANSHAN INDUSTRY ZONE LONGKOU CITY SHANDONG

PROVINCE CHINA

TEST REPORTS

Order No.: A3038 Test Date: 2007.8.31
Description of Goods: Square Tube-Rnd .Cmn. Alloy /Temper: 6061-T6511
Standard For Test: ASTM B221-2004 AMS-OO-A200/8 AMS 4173 -E
Heat No.: 3599
Net Weight(lbs): 4173.00 Bundle No.: 309-315
Size(Inch): 1.25X1.25X.120X240 Die No.: NSXC107-006

TABLE OF RESULT DETAI

Tube Carr

A. CHEMICAL COMPOSITION

Test Items		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Impurities	
Normal Requirements	Min	0.40	/	0.15	/	0.8	0.04	/	/	Each	Total
	Max	0.80	0.7	0.4	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Test Results		0.59	0.12	0.22	0.01	1.01	0.13	0.006	0.006	0.05	0.15

B. MECHANICAL PROPERTY

Test Items	Ultimate Strength	Yield Strength	Elongation
Units	KSI(min)	KSI(min)	%
Normal Requirements	38.0	35.0	8
Test Results	46.7	43.0	17

It is hereby certified that the above material is manufactured in compliance with the specified standards and meets the stipulated requirement.

Authorized Department: Quality Test Department

Inspector: *包静*

Quality Manager: Xiaoli Chi

Signature: *梁静*

LONGKOU NANSHAN ALUMINIUM

GENERAL FACTORY

